

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026931**Date Inspected:** 10-Dec-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1400**Contractor:** Watson Bowman ACME**Location:** Buffalo, NY**CWI Name:** Reno Davis**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Seismic joint Hinge A**Summary of Items Observed:**

On this date, Quality Assurance Inspector (QAI) Kenneth Riley was present at the Watson Bowman Acme Corporation (WBA) facility, as requested, in Buffalo, New York to observe fabrication activities of the Seismic Expansion Joint Hinge A lanes for the San Francisco Oakland Bay Bridge (SFOBB) project.

This (QAI) Inspector met with Watson Bowman Acme Corporation (WBA) Quality Control (QCS) Supervisor John Miller and KTA-Tator (ABF Representative), Certified Welding Inspectors (CWI), Mr. Reno Davis. ABF Representatives are the Quality Control personnel for this location.

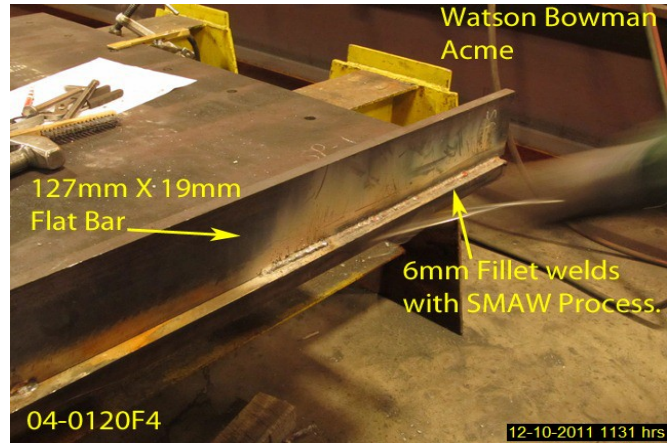
This QAI arrived at WBA and observed Joe Kearns performing clean up and grinding component SEI112667-CA2-16 Mr. Kearns had completed the fillet and groove welding of this component and was addressing imperfection that was observed by WBA in house QC John Miller. Jayson Gray was in process of fitting and welding the 19mm x 127mm flat bar to support plates SEI112667SP-1 and SP2-1 with a 6mm single pass fillet weld. Welder John Ash was observed performing stud welding on the SP3 support plates. The studs being placed were 300mm in length x 22mm in diameter. Approximately 48 studs being welded per SP3 plate. QC personnel Reno Davis was observed onsite performing the ring test on the finished 22mm studs for soundness and a visual observation for 360 degree flash. Mr. Davis was also observed monitoring the welding of these components for the erection aides and flat bars welding where he was verifying the welding parameters for compliance to the Welding Procedure Specification (WPS).

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

Basic conversation, fundamental to completion of the tasks at hand, occurred between this QAI, ABF QC, and WBA personnel .

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Riley, Ken	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell, Bill	QA Reviewer

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